

Work Order ID 81686-1

\*81686\*

Page 1

Friday, March 16, 2012 1:56:17 PM

Item ID: D3782-045

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Back Leg Assembly

Start Date: 3/29/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 3/29/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: 12-03-16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3782	Rev B

100	Pick Kit	0.00
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\*100\*

Packaging

Memo

0.00

Packaging

110	Small Fab	0.00
-----	-----------	------

\*110\*

Small Fab

Memo

0.00

Small Fab

1-assemble as per dwg D3782

120	QC5- Inspect part completeness to step on W/O	0.00
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\*120\*

QC

Memo

0.00

Quality Control

6 0 FF 12-05-08

5 0 FF 12-05-14

5 0 SB 12/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81686****\*81686\***

Page 2

Friday, March 16, 2012 1:56:17 PM

Item ID: D3782-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Back Leg Assembly  
Start Date: 3/29/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 3/29/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>55 Z 56</u>	0.00							
<b>*130*</b>						<u>5</u>		<u>54C 12-5-14</u>	
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/5/15 MF 12-05-15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, March 16, 2012 1:56:21 PM

Page 1

Work Order ID: 81686

\*81686\*

Parent Item: D3782-045

\*D3782-045\*

Parent Item Name: Back Leg Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec  
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C  
10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3772-1 *D3772-1* Back Leg		Manufactured	No			110	Each	2.0000	1	6			
					81695				**	6	(5)	FF 12-05-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST254		2							
					67361	2							
D3787-1 *D3787-1* Foot		Manufactured	No			110	Each	12.0000	1	6			
									**		(5)	FF 12-05-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST249A		12							
					68367	12				6			
D3764-1 *D3764-1* Back Leg Fitting		Manufactured	No			110	Each	1.0000	1	6			
									**		(5)	FF 12-05-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST243		1			*	5			
					74065	1				1			
D3773-041 *D3773-041* Headrest Assembly		Manufactured	No			110	Each	0.0000	1	6			
									**	6	(5)	FF 12-05-14	
D3786-1 *D3786-1* Sleeve		Manufactured	No			110	Each	0.0000	1	6			
									**		(5)	FF 12-05-14	
					81694								
					81673								

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Page 2

Friday, March 16, 2012 1:56:21 PM

Work Order ID: 81686

\*81686\*

Parent Item: D3782-045

\*D3782-045\*

Parent Item Name: Back Leg Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 6.00

Required Qty: 6.00

AN45-15A	Purchased	No	110	Each	12.0000	1	6	
<b>*AN45-15A*</b>						**		(5) FF 12-05-14
EYE BOLT								

Location	Loc Qty	Loc Code
ST362	12	
114523	2	
115908	10	

AN5-15A	Purchased	No	110	Each	99.0000	1	6	
<b>*AN5-15A*</b>						**		(5) FF 12-05-14
Bolt								

Location	Loc Qty	Loc Code
ST338	99	
115159	49	
115316	50	

AN5-17A	Purchased	No	110	Each	80.0000	1	6	
<b>*AN5-17A*</b>						**		(5) FF 12-05-14
Bolt								

Location	Loc Qty	Loc Code
ST338	80	
117872	42	
120498	38	

AN4-15A	Purchased	No	110	Each	367.0000	2	12	
<b>*AN4-15A*</b>						**		(5) FF 12-05-14
Bolt								

Location	Loc Qty	Loc Code
GA	100	
120449	100	
ST358	267	
118706	15	
120187	52	
120422	200	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Work Order ID: 81686

\*81686\*

Parent Item: D3782-045

\*D3782-045\*

Parent Item Name: Back Leg Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 6.00

Required Qty: 6.00

MS21042L4 Purchased No 110 Each 5,519.000 2 12

\*MS21042L 4\*

Nut

\*\*

⑤ FF 12-05-14

Location

Loc Qty

Loc Code

ST300

5519

117441

51

117601

157

118451

133

119017

200

119075

2978

121011

2000

12

MS21042L5 Purchased No 110 Each 1,598.000 3 18

\*MS21042L 5\*

Nut

\*\*

⑤ FF 12-05-14

Location

Loc Qty

Loc Code

ST300

1598

116105

5

116548

43

117611

42

118179

8

119109

1500

18

AN960JD416 NAS1149D0463J Purchased No 110 Each 14.0000 4 24

\*AN960.ID416\*

Washer

\*\*

⑤ FF 12-05-14

Location

Loc Qty

Loc Code

ST351

14

116289

14

24

AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000 5 30

\*AN960.ID516\*

Washer

\*\*

30

⑤ FF 12-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

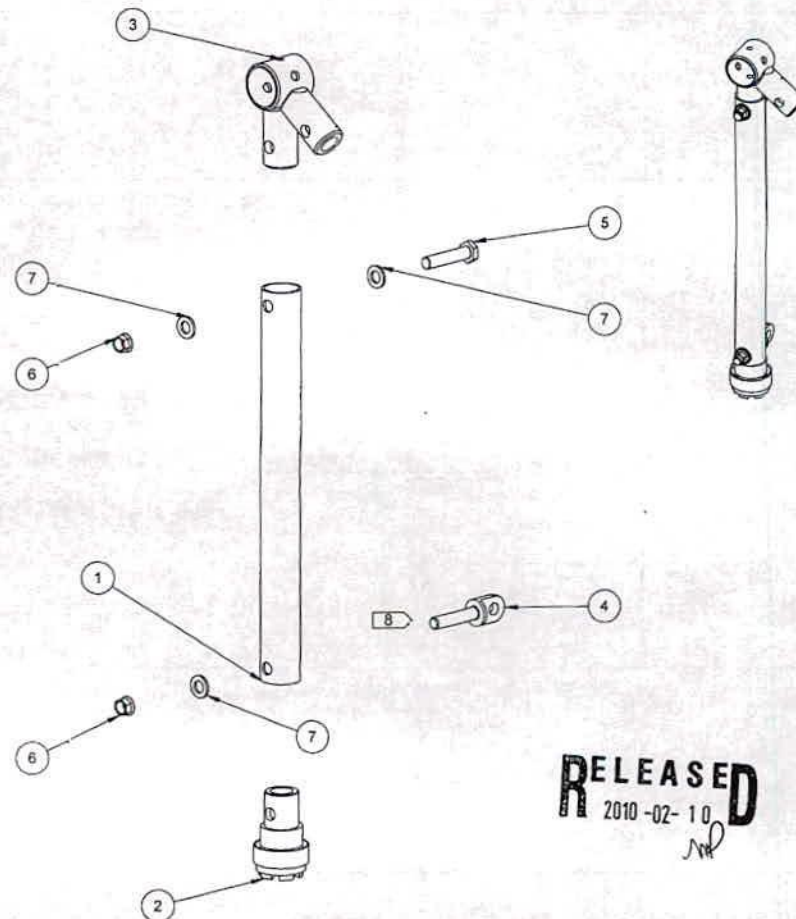
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 91684  
12-03-16



# **D3782-041 FRONT INBOARD LEG ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH  
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

**RELEASED**  
2010-02-10

B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7	10.01.21
A	NEW ISSUE	HS 08.06.04
REV.	DESCRIPTION	BY DATE
DESIGN	DESIGNER	DATE
DRAWN	DRAWN	DATE
CHECKED	CHECKED	DATE
MFG. APPR.	MFG. APPR.	DATE
APPROVED	APPROVED	DATE
DE APPR.	DE APPR.	DATE
DATE	10.01.21	

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3782</b>	REV. B SHEET 1 OF 4
TITLE <b>LEG ASSEMBLY</b>	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

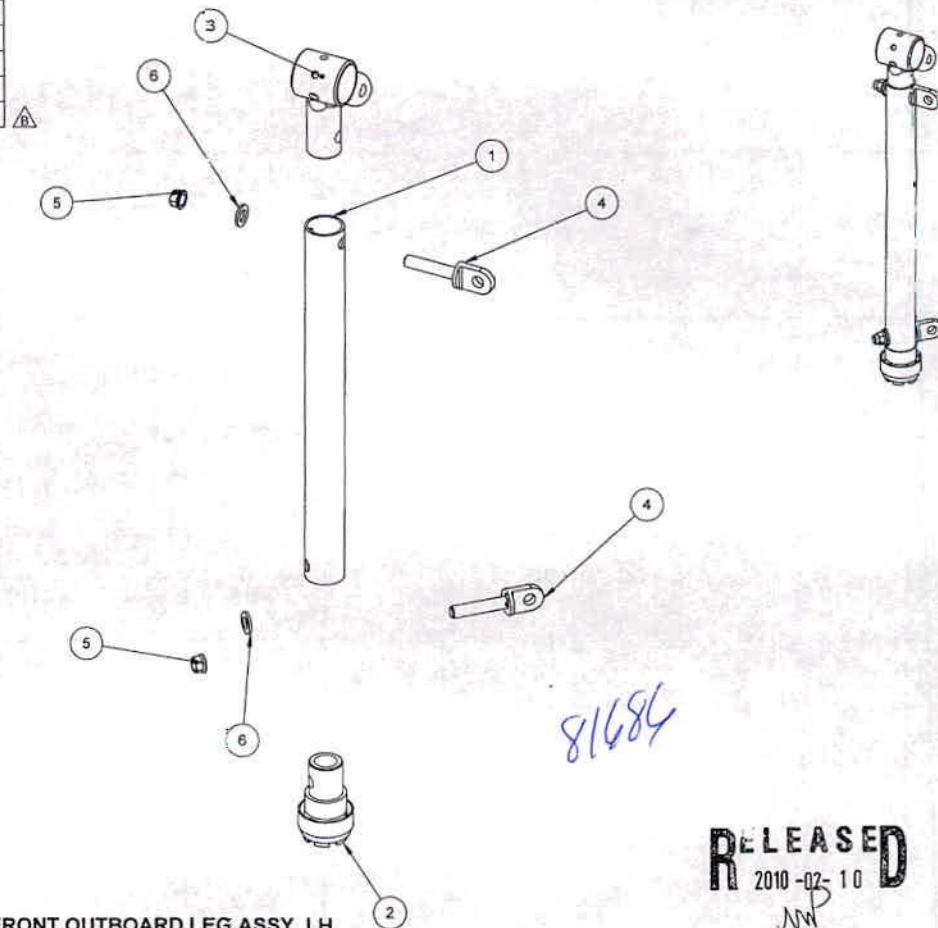
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. (-043)	PART NUMBER	DESCRIPTION
1	1	D3768-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



**D3782-043 FRONT OUTBOARD LEG ASSY, LH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3782</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

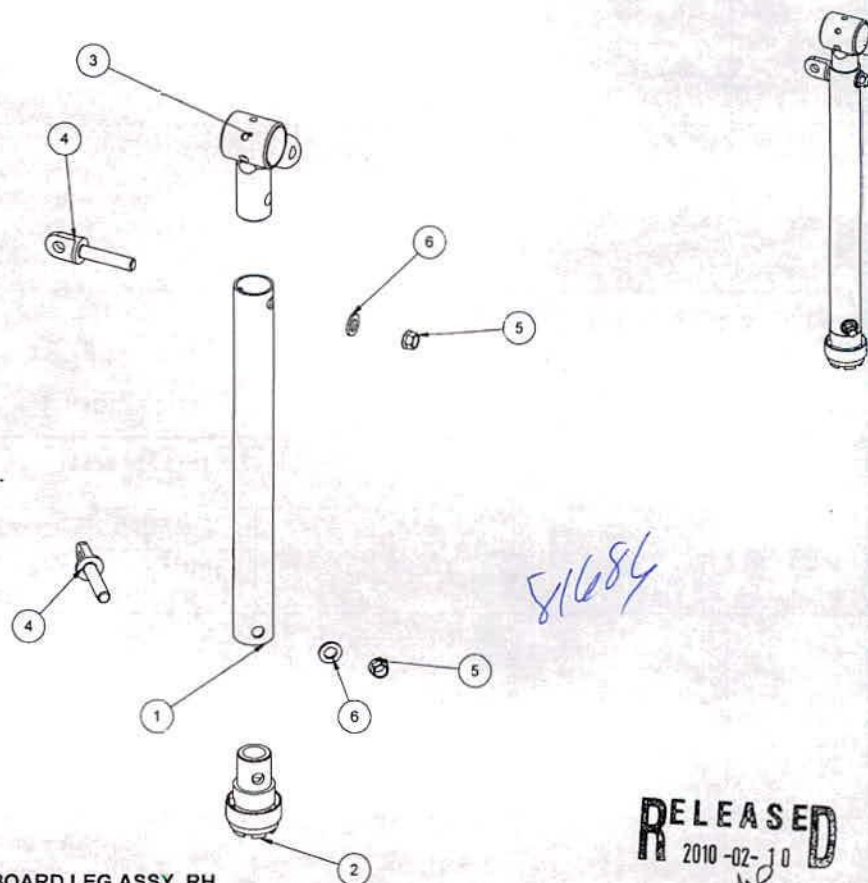
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3782-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



**D3782-044 FRONT OUTBOARD LEG ASSY, RH**

**RELEASED**  
2010-02-10  
No

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3782</b>
MFG. APPR.		REV. B
APPROVED		TITLE <b>LEG ASSEMBLY</b>
DE APPR.		SCALE <b>NTS</b>
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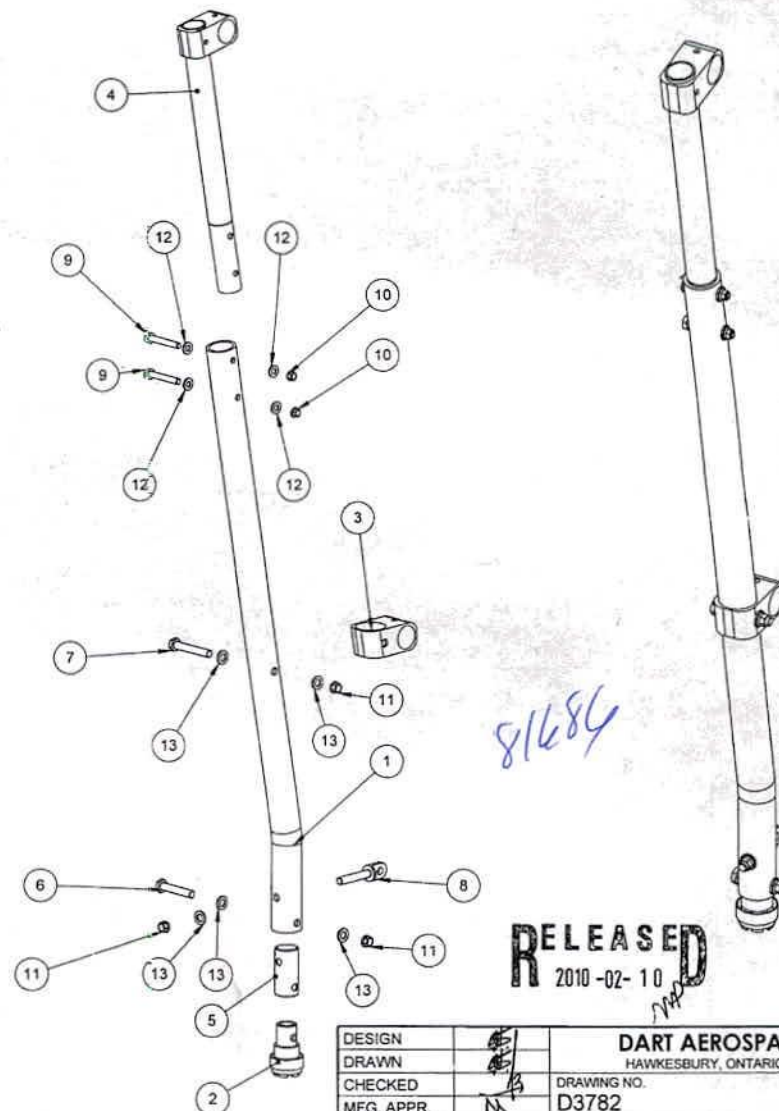
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ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0453J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)



**D3782-045 BACK LEG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.71 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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